



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 174895



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 6/6/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/4/18	0.00	0.00	Start Up Large Fab-4		SL _u
110	Large Fab	10 pcs		6/5/18	0.00	10.00	Large Fab 2		SL _u
120	QC	10 pcs		6/5/18	0.00	0.00	QC9		18-05-31
130	QC	10 pcs		6/5/18	0.00	0.00	QC5		18-05-31
140	HandFinish	10 pcs		6/5/18	0.00	1.87	HandFinish1		BEB 18-05-31
150	QC	10 pcs		6/5/18	0.00	0.00	QC7-2		CPL
180	Large Fab	10 pcs		6/5/18	0.00	10.00	Large Fab 2		SL _u
190	QC	10 pcs		6/5/18	0.00	0.00	QC10		18-06-11
200	QC	10 pcs		6/5/18	0.00	0.00	QC5		18-06-11
210	HandFinish	10 pcs		6/5/18	0.00	1.87	HandFinish1		SA 18-06-11
220	Powdercoat	10 pcs		6/5/18	0.00	2.98	Powdercoat1		DL 18-6-11
230	HandFinish	10 pcs		6/6/18	0.00	1.87	HandFinish3		BEB 18-06-12
240	QC	10 pcs		6/6/18	0.00	0.00	QC3		JUN 13 2018
250	Packaging	10 pcs		6/6/18	0.00	0.00	Packaging1-3		9-89
260	QC	10 pcs		6/6/18	0.00	0.00	QC4		M. H
265	DC	10 pcs		6/6/18	0.00	0.00	DC		M. H
270	Packaging	10 pcs		6/6/18	0.00	0.00	Packaging3		21
280	QC21-FG	10 Ea		6/6/18	0.00	0.00	QC21		18-06-14

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 7:55 OVEN TEMPERATURE: 300 FINISH TIME: 5:25

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

wing walk. M138851

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5070370
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5070282
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5074069
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	506640/507847
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5078428
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	79	0
	D3219-1	20	93	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	1	0
	D3066-1	20	72	0
	MS20600-AD4W4	160	1,071	0
250-Packaging	AN3-35A	20	256	0
	AN4-13A	80	525	0
	AN5-36A	20	230	0
	D2230-3	40	191	0
	D2618	20	420	0
	D2856-400	12	48	0
	D3235-1	20	250	0
	D3278-041	10	19	0
	MS21042L3	20	2,638	0
	MS21042L4	80	2,392	0
	MS21042L5	20	696	0
	NAS1149D0363J	40	3,095	0
	NAS1149D0463J	160	3,234	0
	NAS1149D0563J	40	2,035	0

Part Specifications

Specifications could not be found.

180- #3684

Plex 3/22/18 3:39 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury ON K6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S072403



Part: D350-591-312

Job No: 174895

Serial No/Batch: S072403

Revision:

Inspector:

Date: 05/17/18

S072403



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003862	S081047	AN3-35A	Bolt	s047337	ST348	20
003862	S081046	AN4-13A	Bolt	s067892	OVER003	80
003862	S081045	AN5-36A	Bolt	s048292	ST336	20
003862	S081043	D2230-3	Mounting Lug	s080361	ST521	40
003862	S081042	D2618	Bushing	s049859	ST008	20
003862	S081041	D2856-400-720	Abrasion Strip 4" X 7.20"	s068921	ST418	20
003862	S081038	D3235-1	Mounting Lug	s053650	ST522	20
003862	S081037	D3278-041	Support Assembly	s076688	ST522	10
003862	S081036	MS21042L3	Nut	s078167	OVER007	20
003862	S081035	MS21042L4	Nut	s078254	ST303	80
003862	S081034	MS21042L5	Nut	s041167	ST303	20
003862	S081033	NAS1149D0363J	Washer	s015269	ST263	40
003862	S081032	NAS1149D0463J	Washer	s055952	ST263	160
003862	S081031	NAS1149D0563J	Washer	s068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/14/18 7:08 AM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.